

Work Order ID 146857

146857

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Tuesday, May 24, 2016 9:57:38 AM

Item ID: D412-704-015

Revision ID: URF 16-577

Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016 Start Qty: 1.00

Required Date: 6/17/2016 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: J Date: _____ Tooling: _____ Date: _____

QC: J Date: _____ SPC (Y/N): _____ Date: _____

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
IIN-D412-704	D U/R	OK	UP	16/6/2					

100	Document Control	0.00							
-----	------------------	------	--	--	--	--	--	--	--

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and create labels per PPP D412-704-015 CH6002

0.00

JUL 2 5 2016

DAS
27
9-89

JUL 2 6 2016

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110

Packaging

Packaging

Memo

0.00

DAS
28
9-89

JUL 2 5 2016

120	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Quality Control

Memo

0.03

DAS
27
9-89

JUL 2 6 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER :							

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Item ID: D412-704-015 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: URF 16-577 Stop ***NS2***
 Item Name: Co-Pilot's Emergency Cargo Release
 Start Date: 6/10/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/17/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-704-015 Location: _____ PPP Rev: <u>Sold</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

~~WASTE SOLD~~

DO NOT SHIP TO
 BELL

FOR
 STL

SMB
 10/1/27

DAS
 21
 9-89 JUL 27 2016

DAS
 21
 9-89 JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Junè 23, 2016 2:22:48 PM

146857

D412-704-015

Start Date: 6/10/2016**Required Date:** 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC IPP
REV:B 12.04.20 per cen-566 DD verf:EC IPP REV:C
12.05.10 per ECN 12-583 DD verf:EC IPP REV:D 16.06.22
PER IIN REV:E DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3206-3 *D3206-3* Pedal Arm		Manufactured	No				Each	2.0000		1			DAS 28 9-89 PC
	DAS 27 9-89			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				prelim			2						
					146154		2						
D412-704-141 *D412-704-141* Pedal Assembly		Manufactured	No			110	Each	0.0000	1	1			DAS 28 9-89 X B 145989 PC
D412-704-045 *D412-704-045* Cable Ass'y		Manufactured	No			110	Each	0.0000	1	1			DAS 28 9-89 X B 145771 PC
D3207-5 *D3207-5* Bracket		Manufactured	No			110	Each	2.0000	1	1			DAS 28 9-89 X B 147507 PC
	DAS 27 9-89			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST024			2						
					116991		2						
D3207-7 *D3207-7* Packer		Manufactured	No			110	Each	60.0000	1	1			DAS 28 9-89 PC
	DAS 27 9-89			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST024			60						
					110077		1						
					145451		59						

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Picklist Print

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Work Order ID: 146857

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Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D3207-9 Manufactured No

110 Each 2.0000 1 1

D3207-9

Bracket
DAS
27
9-89

**

PC DAS
28
9-89

Location	Loc Qty	Loc Code
ST024	2	
122604	2	

D3208-1 Manufactured No

110 Each 10.0000 1 1

D3208-1

Doubler
DAS
27
9-89

**

PC DAS
28
9-89

Location	Loc Qty	Loc Code
ST025	10	
141492	10	

D3208-11 Manufactured No

110 Each 12.0000 1 1

D3208-11

Filler
DAS
27
9-89

**

PC DAS
28
9-89

Location	Loc Qty	Loc Code
ST026	12	
141386	12	

D3208-3 Manufactured No

110 Each 13.0000 1 1

D3208-3

Pedal Mount Angle
DAS
27
9-89

**

PC DAS
28
9-89

Location	Loc Qty	Loc Code
ST025	13	
146022	13	

D3208-7 Manufactured No

110 Each 11.0000 1 1

D3208-7

Filler
DAS
27
9-89

**

PC DAS
28
9-89

Location	Loc Qty	Loc Code
ST025	11	
142866	11	

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Work Order ID: 146857

146857

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D3208-9
D3208-9

Doubler

Manufactured No 110 Each 8.0000 1 1

**

PZ DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST025

8

142241

8

D3214-1
D3214-1

Decal

Manufactured No 110 Each 10.0000 1 1

**

PZ DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST026

10

141572

10

D4610-1
D4610-1

Doubler

Manufactured No 110 Each 5.0000 1 1

**

PZ DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST112

5

119696

5

D4610-3
D4610-3

Doubler

Manufactured No 110 Each 14.0000 1 1

**

PZ DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST112

14

142233

14

D4610-7
D4610-7

Cover

Manufactured No 110 Each 18.0000 1 1

**

PZ DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST112

18

142239

18

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Work Order ID: 146857

146857

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

MS21919-DG5

Purchased

No

110

Each

20.0000

4

4

MS21919-DG5

Clamp

**

PC DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST293

20

m134134

20

D4622-1

Manufactured

No

110

Each

7.0000

1

1

D4622-1

Placard

**

PC DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

st113

7

132587

1

147430

6

D4622-3

Manufactured

No

110

Each

3.0000

1

1

D4622-3

Placard

**

PC DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

st113

3

132697

3

MS35489-149

Purchased

No

110

Each

83.0000

1

1

MS35489-149

GROMMET

**

PC DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST269

83

121692

83

JUL 25 2016

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Shop Packet Print

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
X							D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	X						D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
		X					D412-704-015	COPILOT'S EMERGENCY CARGO RELEASE KIT (412)
1	1		X				D412-704-041	PEDAL ASSEMBLY (205/210/212/214)
		1		X			D412-704-141	PEDAL ASSEMBLY (412)
	1				X		D205-704-043	CABLE ASSEMBLY (205)
1		1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1			D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
		1					D3206-3	PEDAL ARM
	1						D3207-1	BRACKET
	1						D3207-3	BRACKET
1		1					D3207-5	BRACKET
1	1	1					D3207-7	PACKER
		1					D3207-9	BRACKET
1							D3207-11	BRACKET
1	1	1					D3208-1	DOUBLER (OR ECM 999709-1)
1	1	1					D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1						D3208-5	MOUNT ANGLE
1	1	1					D3208-7	FILLER (OR ECM 999709-3)
1		1					D3208-9	DOUBLER
1		1					D3208-11	FILLER
			1	1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1	1					D3214-1	PLACARD (OR ECM 999712-1)
					1		D3217-1	CABLE
						1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		1					D4610-1	DOUBLER
		1					D4610-3	DOUBLER
			1	1			D4610-5	SHIM
		1					D4610-7	COVER
				1			D4611-1	BUSHING
		1					D4622-1	PLACARD
		1					D4622-3	PLACARD
			1	1	1	1	AN3-10A	BOLT
			1	1			AN315-4R	NUT
					1	1	AN3-5A	BOLT
			2	2			AN3-6A	BOLT
			1	1			AN4-10A	BOLT
			2				AN4-11A	BOLT
				2			AN4-12A	BOLT
			1				AN4-13A	BOLT
				1			MS20002-4	WASHER
				1			MS20004-24	BOLT

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Revision: E

Date: 16.05.05

Work Order ID 146857

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146857

Page 1

Item ID: D412-704-015

Revision ID: URF 16-577

Item Name: Co-Pilot's Emergency Cargo Release

updated Bom Accept

N900040100

Setup Start

NS1

Stop

NS2

Start Date: 6/10/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-704	D U/R								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-704-015 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS
21
9-89

JUL 25 2016

DAS
21
9-89

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DAS
21
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003 per attachment

Change Record

Part Number: D412-704-015

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Description: CO-PILOT EMERGENCY CARGO RELEASE (412)

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					